

Date: Wednesday, 2/8/2006 7:06:54 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER	
Job Number	: 25733		Part Number	D314092	
Estimate Number	: 11466		Drawing Number	D3140 REV C	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 2/8/2006 S.O. No. : N/A		Drawing Revision	: C	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 2/15/2006 Qty: 2 Um: Each	
Previous Run					
Written By	<u>SEE COMMENT BELOW</u>				
Checked & Approved By	<u>JL</u>				
Comment	Est. A02.04.30 New Issue NG				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S032	2024-T3 .032 sheet
		<i>M18147 ml 06/02/09</i>
Comment: Qty.: 0.1549 sf(s)/Unit Total : 0.3098 sf(s)		
2024-T3 .032 sheet		
Matl: 2024-T3 (QQ-A-250/4) .032" thick		
(M2024T3S.032) 5.00" x 4.06" flat pattern ref		
Note grain direction Batch		
2.0 SHEAR	SHEAR	
<i>ml 06/02/09</i>		
Comment: SHEAR		
Cut as per dwg D3140		
3.0 HAAS1	HAAS CNC VERTICAL MACHINING #1	
<i>Made by Wurd ml 06/02/09</i>		
Comment: HAAS CNC VERTICAL MACHINING #1		
Deburr. No sharp edges		
Notch out .75 x .40 corner as per dwg (-91 shown)		
Form as per dwg (-91 shown) -092	<i>U</i>	<i>SB 06/02/13</i>
4.0 QC5	INSPECT WORK TO CURRENT STEP	
<i>J 06/02/13</i>		
Comment: INSPECT WORK TO CURRENT STEP		
5.0 HAND FINISHING1	HAND FINISHING RESOURCE #1	
<i>ml 06/02/09</i>		
Comment: HAND FINISHING RESOURCE #1		
Chemical Conversion Coat as per QSI 005 4.1		
		<i>5AD 06/02/15 Z</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/02/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Jab60215

'2

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *✓*

Cd6102120 (2)

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21 *545-06/02/21 (2)*

(2) 06/02/21

Job Completion



W/O:		WORK ORDER CHANGES					
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